Qty:

Tuesday, 2/14/2006 8:55:36 AM

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 25810

Estimate Number

: 10518

P.O. Number

:NIA

This Issue

: 2/14/2006

: NC

S.O. No. : NIA

: NIA :NIA

Type

: MACHINED PARTS

Part Number Drawing Number

Drawing Name

: BUSHING

: D28063 : D2806 REV A

Project Number

: N/A

Drawing Revision

Material **Due Date** :NIA

: 2/21/2006

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

05.03.11 Part now turned

:SEE COMMENT BELOW

KJ/JLM

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:

M6061T6H1000

6061-T6 1" HexBar

0.0962 f(s)/Unit Total: Comment: Qty.:

1.9236 f(s)

6061-T6 Hex Bar 1.0"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar

(M6061T6H1.000)

Batch: M/7030

HARDINGE CNC LATHE SMALL

MS OGIOZIIS

2.0

HARDINGE

Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA105 and Dwg D2806

11/8

06/02/15

2-Tumble N/A 3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

O6103

20

4.0

CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE

Drill as per Dwg D2806

5.0

QC8

SECOND CHECK

Comment: SECOND CHECK

-)m

20

1

Page 1

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER C	CHANGES			,				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	:	PAR #: Fault Category:	NCR: Yes	(No) DO	ASSI	Date: 🔿	Waba			

ait 140.	FAN #	rault Category.	NCR. Tes (NO DCA:	nate: Op/29-D/c
			QA: N/C Closed:	Date:

NCR:		-	,	WORK ORDI	ER NON-CONFORMANO	E (NCR)						
	T	_	Description of NC		Corrective Action Section B				<u> </u>			
DATE	STEP		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
					-							
							,					
								ļ				
					· · · · · · · · · · · · · · · · · · ·				!			
•				·					·			
4												
						ŀ	•					

NOTE: Date & initial all entries

Date:

Tuesday, 2/14/2006 8:55:36 AM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 25810

Part Number: D28063

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

8.0

PACKAGING 1



PACKAGING RESOURCE #1

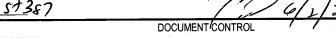


Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:___

9.0





Comment: DOCUMENT CONTROL Inspection Level 21



Job Completion



Dart Ae	rospace	e Ltd						
W/O:			W	ORK ORDER CHANGE	S			
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
•								
		· .						
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA :	Date: _	
					QA: N/	C Closed:	Date: _	
NCR:		V	VORK ORD	ER NON-CONFORMAI	NCE (NCR)		
		Description of NC		Corrective Action Section	n B	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
		•						

		Description of NC	·	Corrective Action Section B			A I	A
DATE	STEP	Section A Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
		·						
						:		
						1		
								1

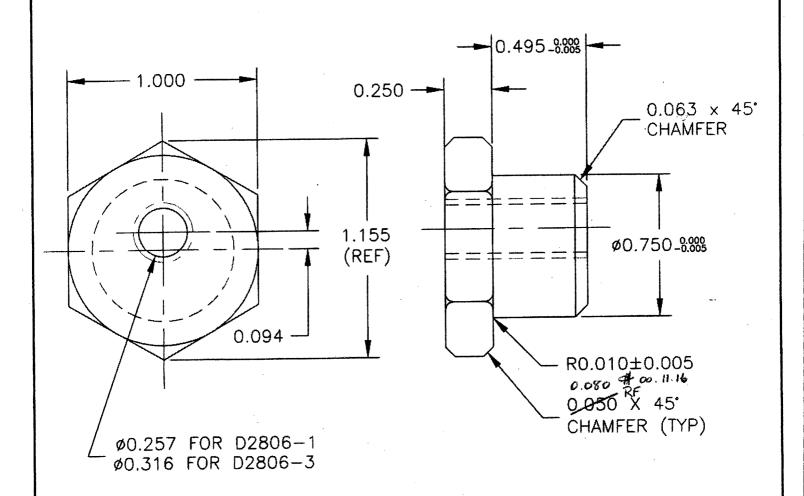
NOTE: Date & initial all entries





	DESIGN	DRAWN BY	DART AEROS HAWKESBURY, ONT	
	CHECKED	APPROVED	DRAWING NO. D2806	REV. A SHEET 1 OF 1
	DATE	<u> </u>	TITLE	SCALE
,	00.11.	08	BUSHING	2:1
	A	00.11.0	NEW ISSUE	

RELEASED



D2806-1 (DRILL Ø0.257 HOLE) D2806-3 (DRILL Ø0.316 HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

W/O: WORK ORDER CHANGES							** * *****
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				***************************************		, ,	
Part No	·	PAR #: Fault Category:	NCR: Yes	No DQ	A :	_ Date: _	

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR)						
	Ī	Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C					
		`				,					

NOTE: Date & initial all entries

DART AEROSPACE LTD Work Order:

Description: Bushing Part Number: D2806-3

Inspection Dwg: D2806 Rev: A Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.005	V			
1.155	+/-0.010	1.149				
0.250	+/-0.010	, 251				
0.063 x 45°	+/-0.010	.063.				
0.080 x 45°	+/-0.010	80.				
0.495	+0.000/-0.005	मवम	V			
0.750	+0.000/-0.005	.750				
Ø0.316	+0.005/-0.000					
						·

Measured by:	Audited by:	my	Prototype Approval:	N/A
Date: Octobalis	Date:	06/02/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.02.25	New Issue	KJ/RF	